COR™STAIN 502 FC

DESCRIPTION
COR™STAIN 502 FC is an AISI 5%Cr-0.5%Mo steel designed for heat resistance. This wire is available in metal core or flux core.

APPLICATIONS
502 FC is used to weld chrome-moly pipe and tube, and other similar base materials. It is also used as an underlay for harder heat resisting filler metals.

PROCEDURE
502 FC is an air-hardening alloy: Maintain a preheat/interpass temperature of at least 350°F. Post heat according to base material. Recommended post heat is at 1575°F for one hour per inch thickness.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Type</th>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas</th>
<th>Stickout</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC-G</td>
<td>.045”</td>
<td>18-21</td>
<td>150-200</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.5”</td>
</tr>
<tr>
<td>FC-G</td>
<td>.045”</td>
<td>24-28</td>
<td>150-200</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.5”</td>
</tr>
<tr>
<td>FC-G</td>
<td>1/16”</td>
<td>26-30</td>
<td>200-300</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.75”</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Hardness: 32-37 Rc

CLASSIFICATION
AWS A5.22, Class E502T0-X